








DRAW GREEN

Work Order ID 65514

January 19, 2011 11:30:46 AM



Item ID: D2572 Accept  Setup Start 
Revision ID: Stop 
Item Name: Saddle, Fwd In 205
Start Date: 1/20/11 Start Qty: 10.00  Cust Item ID:
Required Date: 2/11/11 Req'd Qty: 10.00  Customer:
Reference:

Approvals: Process Plan: W Date: Tooling: Date: Run Start 
QC: Date: SPC (Y/N): Date: Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2572	Rev E								

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program Batch No. 65514
Double check by: B.A.
1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
3-Machine Step No 3 per Folio FA051 and insp

SL 11/01/27 (10)

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine keyway as per dwg D2571 & D2572

SL 11/01/27 10 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65514

January 19, 2011 11:30:46 AM



Page 2

Item ID: D2572

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, Fwd In 205

Start Date: 1/20/11 Start Qty: 10.00



Cust Item ID:

Required Date: 2/11/11 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00	SL	11/01/27		10	0		
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	BA	11/01/27		10	0		
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				10			BR 11-01-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65514

January 19, 2011 11:30:47 AM



Page 3

Item ID:	D2572	Accept		Setup	Start	
Revision ID:						
Item Name:	Saddle, Fwd In 205				Stop	
Start Date:	1/20/11	Start Qty:	10.00			
Required Date:	2/11/11	Req'd Qty:	10.00			
Reference:						
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 	White Cross (Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat									
Powder Coating	Memo POWDER COAT DRAB GREEN PER QSI 005 START TIME: 11:15 OVEN TEMPERATURE: 320 FINISH TIME: 12:15	0.00							10x m.d 11/03/01
160 	QC3- Inspect Part Finish	0.00							
QC									
Quality Control	Memo	0.00							10 y 11/03/01
170 	Identify as per dwg & Stock Location	0.00							
Packaging									
Packaging	Memo	0.00							11/3/11 SP 10x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65514

January 19, 2011 11:30:47 AM



Page 4

Item ID: D2572

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, Fwd In 205

Start Date: 1/20/11 Start Qty: 10.00



Cust Item ID:

Required Date: 2/11/11 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21-Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/03/02

CD 11/03/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 19, 2011 11:30:45 AM

Page 1

Work Order ID: 65514

Parent Item: D2572

Parent Item Name: Saddle, Fwd In 205




Start Date: 1/20/11

Required Date: 2/11/11

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: I02.10.02 Re-format; Change to Dwg Rev. D & incorporated
D2572 KJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-005  Saddle Billet		Manufactured	No			100	Each	17.0000	1	10		21/01/26	

Location

Loc Qty

Loc Code

MAT46

17

46411

1

✓ 62394

16

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 65814
Description: Saddle, Fwd Inboard	Part Number: D2572
Inspection Dwg: D2572 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.442	.442	.442	.442	Vern	11-3
B	1.745	1.755		1.750	1.750	1.750	1.750		"
C	3.495	3.505		3.500	3.500	3.500	3.500		"
D	1.745	1.755		1.750	1.750	1.750	1.750		"
E	7.990	8.010		8.001	8.001	8.001	8.001	Vern	CNC-02
F	0.490	0.510		.499	.501	.502	.500		"
G	0.257	0.262		.258	.258	.258	.258		"
H	0.375	0.380		.376	.376	.376	.376		"
I	0.490	0.510		.501	.502	.500	.501		"
J	1.174	1.184		1.179	1.179	1.179	1.179		"
K	0.558	0.578		.569	.568	.568	.568		"
L	1.174	1.184		1.179	1.179	1.179	1.179		"
M	1.490	1.500		1.495	1.495	1.495	1.495		"
N	2.495	2.505		2.500	2.500	2.500	2.500		"
O	3.869	3.879		3.874	3.874	3.874	3.874		"
P	0.115	0.135		.126	.125	.125	.126	mic	118-120
Q	0.115	0.135		.135	.135	.135	.135		"
R	0.240	0.260		.250	.250	.250	.250		"
S	0.115	0.135		.128	.130	.129	.129	mic	118-120
T	0.178	0.198		.188	.188	.188	.188		R-G
U	2.940	2.980		2.965	2.960	2.960	2.960		"
V	0.230	0.250		.239	.239	.240	.239		"
W	0.115	0.135		.131	.130	.126	.125	mic	118-120
X	0.307	0.312		.311	.311	.311	.311		"
Y	0.760	0.765		.760	.760	.760	.760		"
Z	0.352	0.372		.365	.365	.364	.363		"
AA	0.470	0.530		.500	.500	.500	.500		R-G
AB	0.615	0.635		.626	.626	.625	.625		"
AC	0.053	0.073		.063	.063	.063	.063		R-G
AD	0.240	0.260		.248	.248	.249	.248		"
AE	1.375	1.395		1.389	1.389	1.388	1.390		dial
AF	0.115	0.135		.135	.135	.135	.135		"
AG	0.240	0.280		.260	.260	.260	.260		"
AH	0.240	0.260		.248	.248	.249	.248		"
AI	2.000	2.020		2.004	2.004	2.003	2.005		dial
AJ	0.023	0.043		.033	.033	.033	.033		"
Accept/Reject									

Measured by: JL
Date: 11/01/24

Audited by: H.A.
Date: 11/01/27

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order: 6584
Description: Saddle, Fwd Inboard	Part Number: D2572
Inspection Dwg: D2572 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.442	.442	.442	.442		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	7.997	8.000	8.001		
F	0.490	0.510		.500	.496	.500	.501		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.376	.376	.376	.376		
I	0.490	0.510		.501	.501	.502	.501		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.568	.568	.570	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.125	.126	.126	.126		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.251	.249	.250	.250		
S	0.115	0.135		.129	.129	.129	.129		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.239	.238	.238	.239		
W	0.115	0.135		.127	.127	.128	.126		
X	0.307	0.312		.311	.311	.311	.311		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.363	.364	.364	.363		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.625	.626	.626	.626		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.248	.247	.248	.249		
AE	1.375	1.395		1.390	1.390	1.390	1.390		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.248	.249	.248	.248		
AI	2.000	2.020		2.005	2.005	2.005	2.005		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	JL
Date:	11/01/27

Audited by:	A.A
Date:	11/01/27

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	05514
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443		.442	.442				
B	1.745	1.755		1.750	1.750				
C	3.495	3.505		3.500	3.500				
D	1.745	1.755		1.750	1.750				
E	7.990	8.010		8.000	8.001				
F	0.490	0.510		.501	.501				
G	0.257	0.262		.258	.258				
H	0.375	0.380		.376	.376				
I	0.490	0.510		.502	.500				
J	1.174	1.184		1.179	1.179				
K	0.558	0.578		.569	.568				
L	1.174	1.184		1.179	1.179				
M	1.490	1.500		1.495	1.495				
N	2.495	2.505		2.500	2.500				
O	3.869	3.879		3.874	3.874				
P	0.115	0.135		.126	.126				
Q	0.115	0.135		.135	.135				
R	0.240	0.260		.250	.250				
S	0.115	0.135		.130	.130				
T	0.178	0.198		.188	.188				
U	2.940	2.980		2.960	2.960				
V	0.230	0.250		.238	.238				
W	0.115	0.135		.127	.126				
X	0.307	0.312		.311	.311				
Y	0.760	0.765		.760	.760				
Z	0.352	0.372		.363	.363				
AA	0.470	0.530		.500	.500				
AB	0.615	0.635		.625	.626				
AC	0.053	0.073		.063	.063				
AD	0.240	0.260		.249	.247				
AE	1.375	1.395		1.391	1.390				
AF	0.115	0.135		.135	.135				
AG	0.240	0.280		.260	.260				
AH	0.240	0.260		.248	.248				
AI	2.000	2.020		2.006	2.005				
AJ	0.023	0.043		.033	.033				
Accept/Reject									

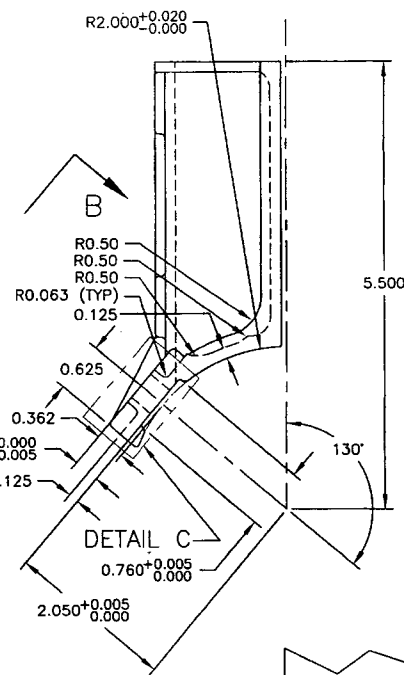
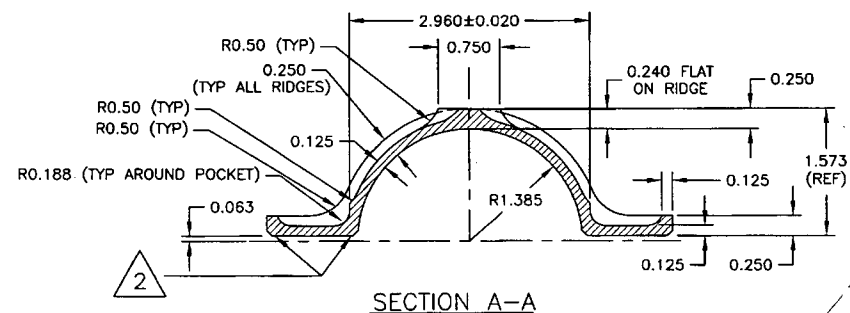
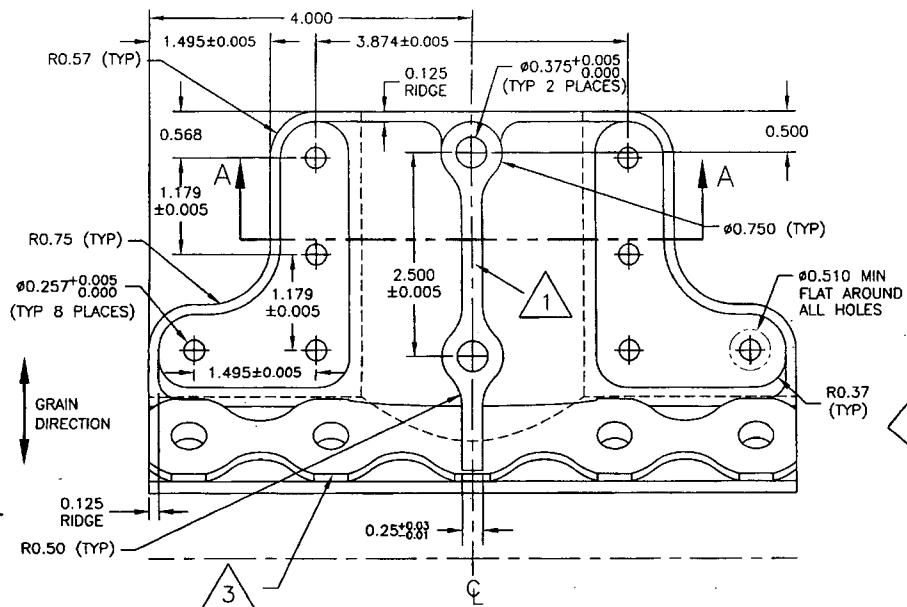
Measured by:	SL
Date:	11/01/27

Audited by:	M.A
Date:	11/01/27

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

RELEASED

05.12.06

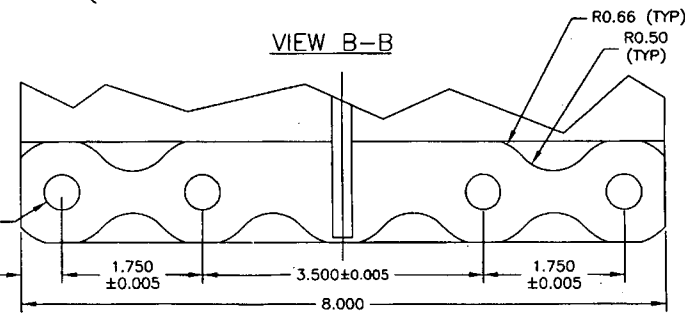


NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)
 (REF DART SPEC. D6102-003)
 FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
 DART QSI 005 4.3
 BREAK ALL SHARP EDGES 0.010 TO 0.020
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND
- 4 CHAMFER 0.033 x 45° (SEE DETAIL C) E

VIEW B-B



DETAIL C
 SCALE 2:1

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 OR COPIED OR COMMUNICATED TO ANY OTHER
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 DART AEROSPACE LTD.

E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN	DS	DART AEROSPACE LTD. HAMPSHIRE, ONTARIO, CANADA
DRAWN BY	PH	
CHECKED		DRAWING NO. D2572
APPROVED		REV. E SHEET 1 OF 1
DATE	05.07.13	TITLE INNER FWD SADDLE SCALE 2:3